

CONFIDENTIAL0-1-53
31-7-53

7

AS-1 MECH DWGS
DC/R+D LAB

P20J 2045

JOB NO. 78-03433ABOX NO. 11FOLDER NO. 7TOTAL DOCS HEREIN 38

DOC	1	REV DATE	25 NOV 1953	BY	064540
ORIG COMP		ORI	38	TYPE	12
ORIG CLASS	M	PAGES	38	REV CL'S	C
JUST	32	NEXT REV	2010	AUTH	HR 102

AS-1 Mechanical Drawings
1953

ORIGINAL CL BY 235979
☒ DECL A REV W ON 2010
 EXT BYNDS YRS BY SAME
 REASON 3d(3)

CONFIDENTIAL

PARTS LIST AS-1 MECHANICAL COMPONENTS

PART NUMBER	NAME	NUMBER	MATERIAL
B-125404XP	Assembly		
A-125427XP	Post	4	Brass SAE #72
A-125428XP	Spacer	3	Brass SAE #72
A-125429XP	Spacer	1	Brass SAE #72
A-125430XP	Gear, Cluster	1	Brass Boston G30 & G138
A-125431XP	Axle	2	1/8 H&G Dowel Pin
A-125432XP	Gear, Spur	1	Brass SAE #72
A-125433XP	Spacer	1	Brass SAE #72
A-125434XP	Axle	1	Drill Rod
A-125435XP	Gear, Cluster	1	Brass Boston G136
A-125436XP	Spacer	1	Brass SAE #72
A-125437XP	Spring, Comp.	1	Piano Wire
A-125438XP	Gear	1	Steel (Cold roll)
A-125439XP	Driver	1	1/8 H&G Dowel Pin
A-125440XP	Coupler and Pinion	1	Drill Rod
A-125441XP	Coupler	1	Drill Rod
A-125442XP	Shim	30	Phosphor Bronze
A-125443XP	Shim	12	Phosphor Bronze
A-125444XP	Shaft	1	Drill Rod
A-125445XP	Spacer	1	Brass SAE #72
A-125446XP	Spacer	1 VOID	Brass SAE #72
A-125447XP	Pinion	1	Steel Boston GS 32
A-125448XP	Gear	1	Brass Boston G 139
A-125449XP	Washer	1	Brass SAE #72
A-125450XP	Washer	1	Brass SAE #72
A-125451XP	Axle	1	Drill Rod
A-125452XP	Worm	1	Steel Boston #HDSH
A-125453XP	Worm	1	Steel Boston #HDSH
A-125454XP	Gear, Worm	1	Bronze Boston #Q1318
A-125455XP	Gear, Worm	1	Bronze Boston #D1118
A-125456XP	Roller, Feed	1	Steel (cold roll)
A-125457XP	Helix	1	Steel (oil HD)
A-125458XP	Bracket, Bearing	1	Alum 24ST-3
A-125459XP	Shaft	1	3/16 H&G Dowel Pin
A-125460XP	Cover	1	Steel (cold roll)
A-125461XP	Guide	1	Steel (cold roll)
A-125462XP	Bracket	1	Steel (cold roll)
A-125463XP	Arm	1	Brass
A-125464XP	Screw, Shoulder	1	Steel (cold roll)
A-125465XP	Rod, Guide	1	Brass
A-125466XP	Spacer	1	Brass
A-125467XP	Roller, Pressure	1	Steel (cold roll)
A-125468XP	Pin	1	Bronze
A-125469XP	Spring, Compression	1	Piano Wire
A-125470XP	Shank	1 VOID (see A-2045-5)	Brass
A-125471XP	Flange	1 VOID (see A-2045-6)	Brass
A-125472XP	Hub	1 VOID (see A-2045-7)	Brass

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CONTINUATION SHEET - PARTS LIST

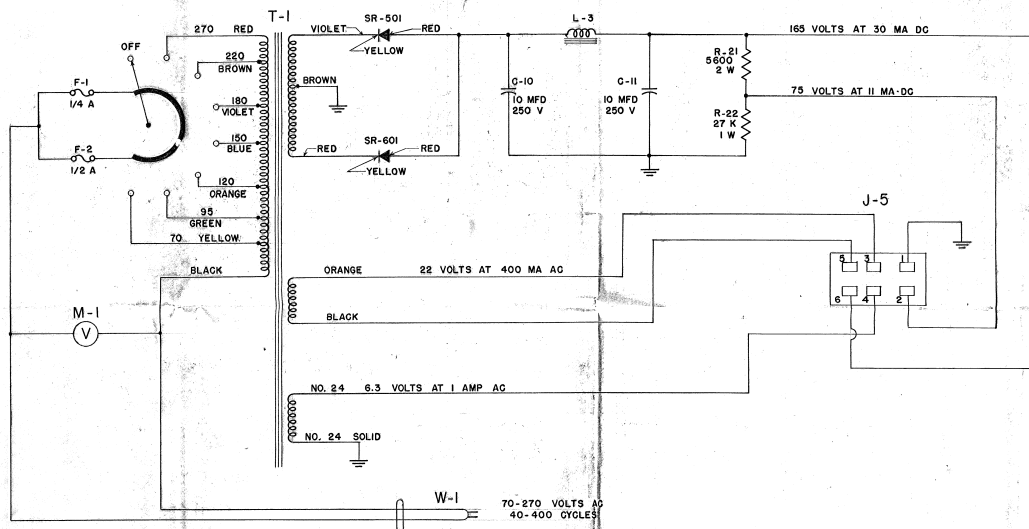
PART NUMBER	NAME	NUMBER	MATERIAL
A-125473XP	Shield	1 VOID (see 2045-8)	Brass
A-125474XP	Spindle	1 VOID (see 2045-9)	1/16 H&G Dowel Pin
A-125475XP	Roller, Ink	1 VOID (see 2045-10)	Hard Felt
A-125476XP	Arm	1 VOID (see 2045-11)	Brass
A-125477XP	Screw, Shoulder	1 VOID (see 2045-12)	Steel (cold roll)
A-125478XP	Spring, Torsion	1 VOID	Piano Wire
A-125479XP	Spacer	1	Brass
A-125480XP	Armature	1 ASM	Note
A-125481XP	Hanger	1	Brass and Drill Rod
A-125482XP	Hanger	1	Brass
A-125483XP	Anvil	1	Steel (cold roll)
A-125484XP	Platen	1	Steel (cold roll)
A-125485XP	Lam., Pole Piece	24	Transformer Steel
A-125486XP	Form, Coil	2	Phenolic Plastic
A-125487XP	Coil	2	Note
A-125488XP	Swivel	1	Brass
A-125489XP	Stop	1	1/8 H&G Dowel Pin
2045-5	Shank	1	Aluminum
2045-6	Flange	1	Brass
2045-7	Hub	1	Brass
2045-8	Shield	1	Aluminum
2045-9	Screw, Spindle	1	1/8 H&G Dowel Pin DRILL ROD
2045-10	Roller, Ink	1	Hard Felt
2045-11	Arm	1	Brass
2045-12	Screw, Shoulder	1	Steel (cold roll)
2045-13	Plate, Frame	1	Aluminum
2045-14	Support	1	Aluminum
2045-15	Angle, Frame	1	Aluminum
2045-16	Plate, Frame	1	Aluminum
2045-17	Assembly, Ink Roller	1	See parts drawing
2045-18	Bearing	5	1/2" Oilite Stock
2045-19	Assembly, Ink pad	1	see part drawings
2045-20	Cover <i>HOLD DOWN</i>	1	Aluminum
2045-21	Spring clamping	1	Spring Steel
2045-24	Pin, locating	1	Drill rod
2045-25	Washer, Spring	1	Phosphor Bronze
2045-26	Chain and Coupling	1	Brass
A-125502XP	Magnet	1	Alnico
B-125408XP	Distributor Asm.		
A-125410XP	Post	2	Brass SAE #72
A-125411XP	Post	1	Brass SAE #72
A-125412XP	Geneva and Sprocket	1	Mach. Steel
A-125413XP	Shaft	1	Mach. Steel
A-125414XP	Sleeve	1	Phenolic Plastic
A-125415XP PT-1	Cam	1	Phosphor Bronze
A-125415XP PT-2	Cam	1	Phosphor Bronze
A-125415XP PT-3	Cam	1	Phosphor Bronze
A-125415XP PT-4	Cam	1	Phosphor Bronze

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CONTINUATION SHEET - PARTS LIST

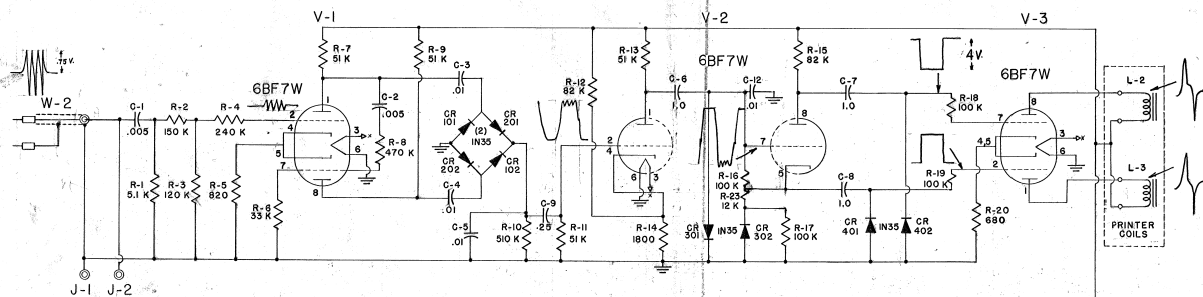
PART NUMBER	NAME	NUMBER	MATERIAL
A-125415XP PT-5	Cam	1	Phosphor Bronze
A-125415XP PT-6	Cam	1	Phosphor Bronze
A-125416XP	Ring	1	Phosphor Bronze
A-125417XP	Spacer	1	Phosphor Bronze
A-125418XP	Plate, Side	2	Aluminum 24S-T3
A-125419XP	Spacer	1	Aluminum 24S-T3
A-125420XP	Lug	1	Aluminum 24S-T3
A-125421XP	Leaf	1	Aluminum 24S-T3
A-125490XP	Housing	1	Black Bakelite
A-125491XP	Contact	1	Brass and Silver
A-125492XP	Washer, Plate	1	Steel (cold roll)
A-125493XP	Insulator	2	Black Bakelite
A-125494XP	Insulator	1	Bakelite
A-125495XP	Bushing, Guide	1	Brass
A-125496XP	Insulator	2	Bakelite
A-125497XP	Spacer	2	Brass
A-125498XP	Contact	8	Brass and Silver
A-125499XP	Spring, compression	8	Piano Wire
A-125501XP	Cover	1	Brass
B-125422XP	Guide	1	Aluminum
A-125423XP	Cleat	1 VOID	Aluminum
A-125423XP	Cleat	1 VOID	Aluminum
A-125425XP	Spring, Torsion	1 VOID (see 2045-3)	Piano Wire
A-125426XP	Catch	1 VOID (see 2045-4)	Aluminum
2045-2	Latchpin	1	Brass
2045-3	Spring	1	Phosphor Bronze
2045-4	Catch	1	Aluminum
C-125601XP	Power Supply Case	1	Aluminum Alloy
D-125407XP	Case Layout	1	
2010-15	Receptacle	1	Brass
2010-16	Reversible Pin	1	Brass
2010-17	Assembly AC line cord	1	see part drawings
2045-22	Schematic AT-1		
2045-23	Schematic AP-1 Power Supply <i>SUPPLY</i>		

TRIM LINE



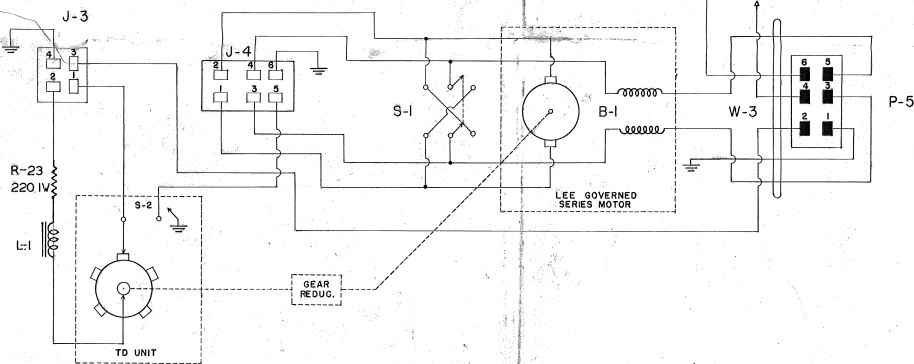
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NO. MODIFICATIONS:	DR. BY: RLB 6-15-53	SCALE: 1/2" = 1"
CH. BY:	SCHEMATIC: ATP-1	POWER SUPPLY
	OWN. NO. 2045-23	



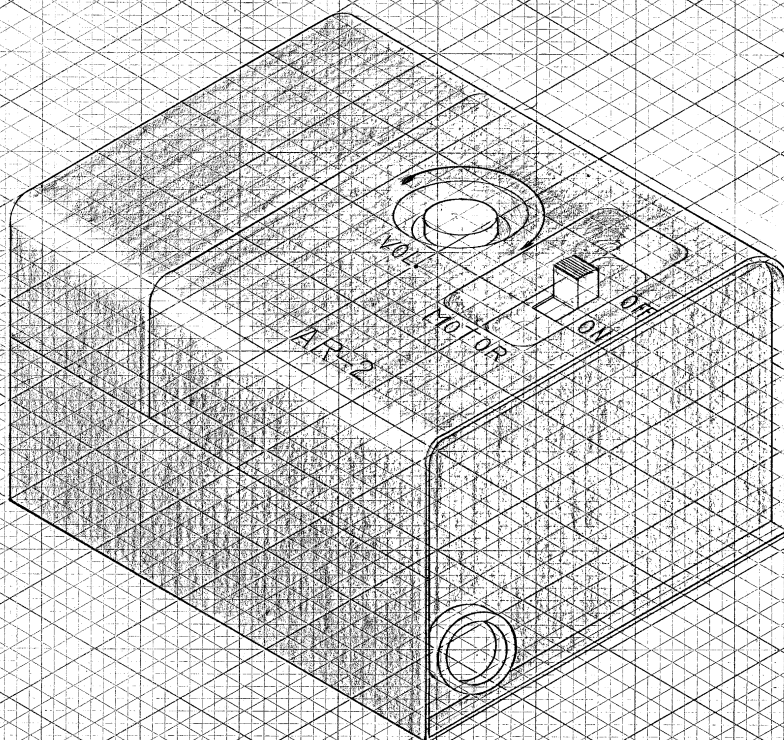
ENG. CHANGE NOTES

1. R-2 68 K.
2. R-12 REMOVED.
3. CR 301, 402 ARE IN34's



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NO.	MODIFICATIONS:	DR. BY: RLB 6-15-53	SCALE: ~
		CH. BY: EJE 6-15-53	SCHEMATIC
			ATP - I
			DWG. NO.
			2045-22



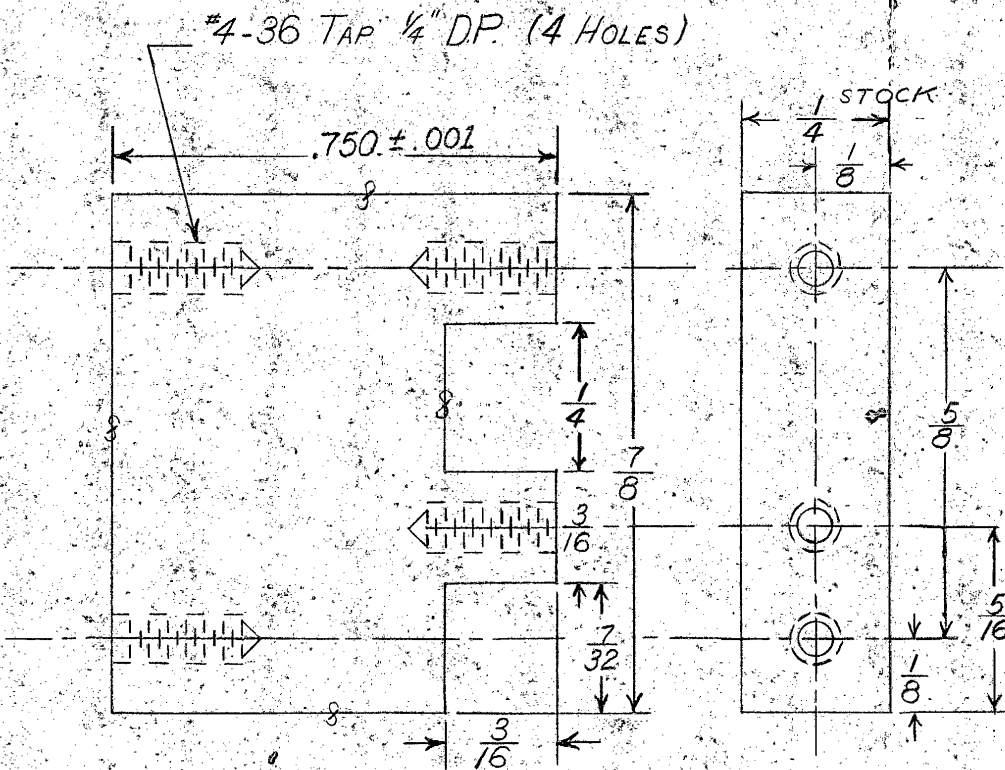
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MAT. ALUM. (1) REQ.

NO.	MODIFICATIONS	Dr. by: DLC 2-19-53	SCALE 1" = 1"
		CH. BY	COVER
			2045-20



MAT. 24 ST. ALUM. (1 REQ.)

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NO.	MODIFICATIONS:	DR. BY: R.L.B 3-4-53	SCALE: 1" = 1/4"
		CH. BY:	
			DWG. NO. 2045-

NOTE 1 - MACHINE MOUNTED EDGES
OF CASE FLID.

NOTE 2 - RIVET HINGE TO CASE
FLID WITH FIVE RIVETS EACH (SEE 40)

NOTE 3 - TOLERANCE ON DIM.
SHOWN AS MIN. TO BE $+1/32$

NOTE 4 - ASSEMBLY DETAIL
CONFORMING TO CASE FLID AS SHOWN IN VIEW
B-D

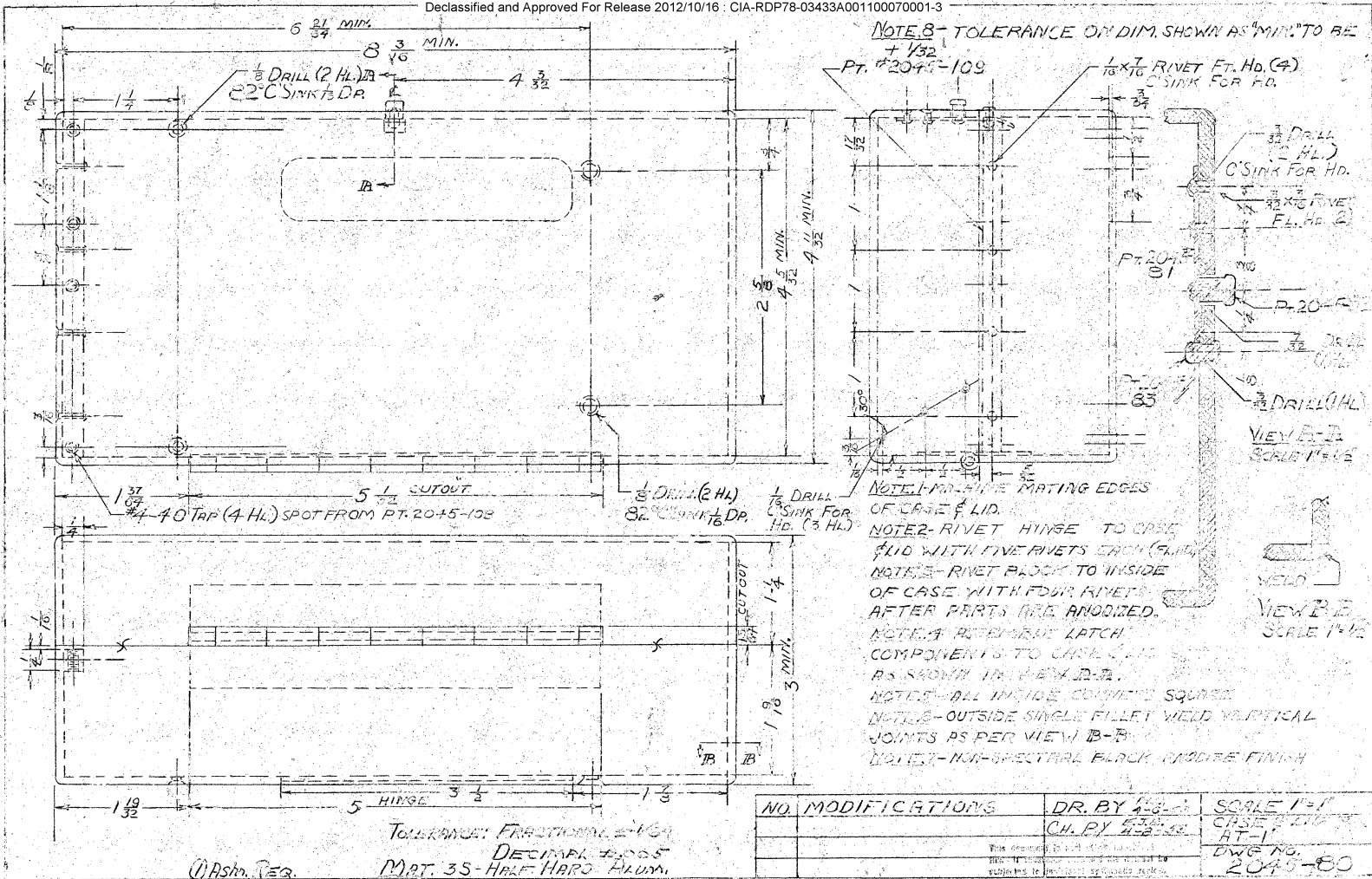
NOTE 5 - ALL INSIDE DIMENSIONS SQUARE

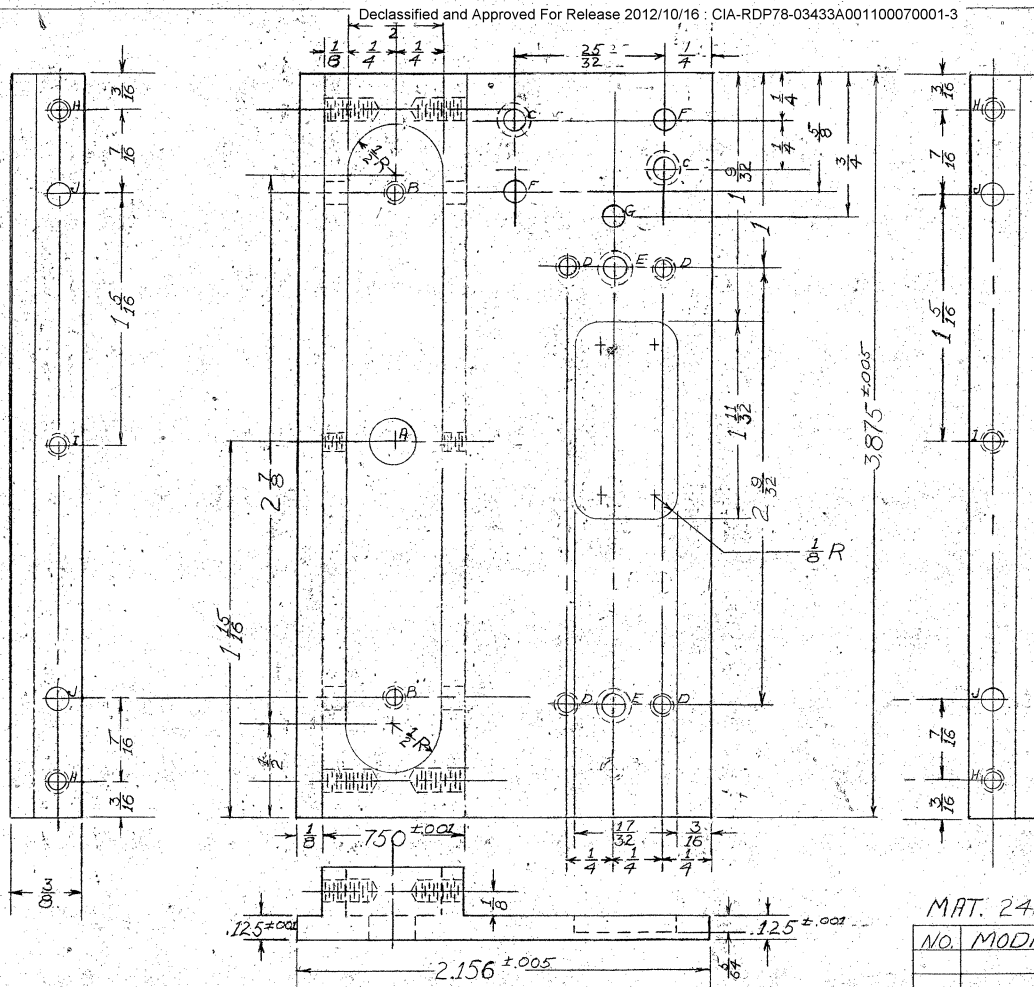
NOTE 6 - OUTSIDE RADIUS RIVET WELD VERTICAL
JOINTS AS PER VIEW B-D

NOTE 7 - NON-SPECTRAL BLACK FINISH FINGER

NOTE 8 - VENTILATING HOLES IN BOTH SIDE OF CASE
7 DIA. @ 1 CENTER TO CENTER IN EACH SIDE

NO.	MODIFICATIONS	EXPIRY DATE	SUBJECT
		CHRY 68-88	CASE 110 FOR ADM.
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HOLE NO.	SIZE
A	1/4 DRILL (OPTIONAL)
B	#4-40 TAP THRU
C	1/8 DRILL 3/16 C.BORE .0900R
D	#4-40 TAP
E	1/8 DRILL 3/16 C.BORE .0900R
F	1/8 REAM(S) AFTER ASM
G	1/8 DRILL
H	#4-40 TAP 1/4 DE.
I	#4-40 TAP THRU
J	1/8 REAM(S) AFTER ASM

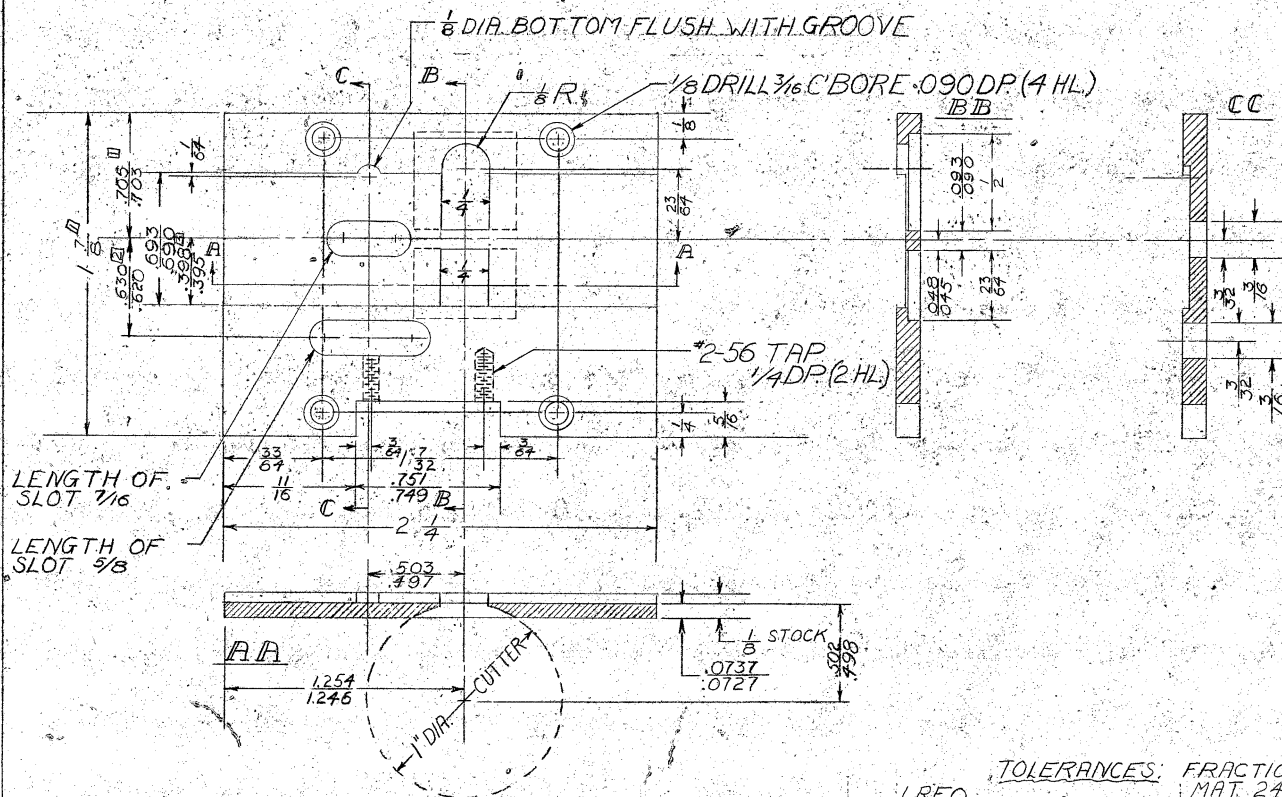
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TOLERANCE: FRACT. DIM. $\pm 1/64$
DEC. DIM. - AS GIVEN

MAT. 24ST ALUM.

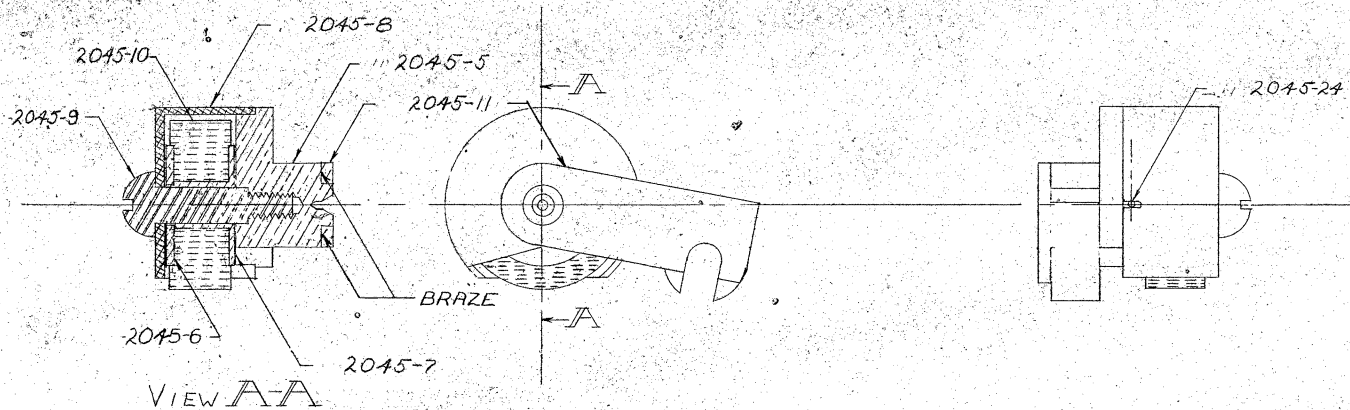
NO. MODIFICATIONS

DR. BY DLC: 14-53
CH. BY
SCALE 1" = 1/2"
BASE
DWG. NO.
2045-44



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TOLERANCES: FRACTIONS = 1/64 DEC. AS SHOWN		SCALE 1" = 1/2"	
NO.	MODIFICATIONS	DR. BY D.A.C. 3-12-53	GUIDE
1	WAS 1.254 ± 1/32 D.A.C. 3-24-53	CH. BY EJE 3-24-53	DWG. NO. 2045-31
2	WAS 1.254 D.A.C. 3-27-53		
3	WAS 1.254 D.A.C. 4-1-53		



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MAT. SEE PTS. DRWGS.

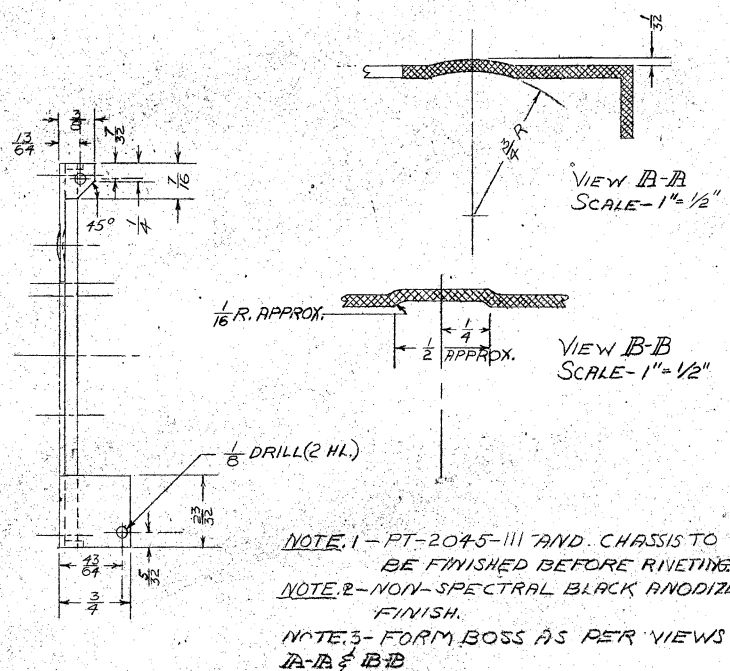
NO.	MODIFICATIONS	Dr. by: D.L.C. 2-20-53	SCALE 1" = 1/2"
		CH. BY D.L.C.	ASM, INK ROLLER
			2045-17

(1) REQ



TOLERANCES: FRAC $\pm 1/64$
3 PLACE DEC. $\pm .005$
4 PLACE DEC. $\pm .0005$
MAT. 24ST ALUM.

NO.	MODIFICATIONS	DRBY D.L.C. 3-4-83	SCALE 1"=1/4"
		CH. BY	PLATE, FRAME
			DWG. NO.
			2045-13



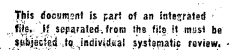
NOTE.1 - PT-2045-III AND CHASSIS TO
BE FINISHED BEFORE RIVETING
NOTE.2 - NON-SPECTRAL BLACK ANODIZE
FINISH.
NOTE.3 - FORM BOSS AS PER VIEWS
A-A & B-B

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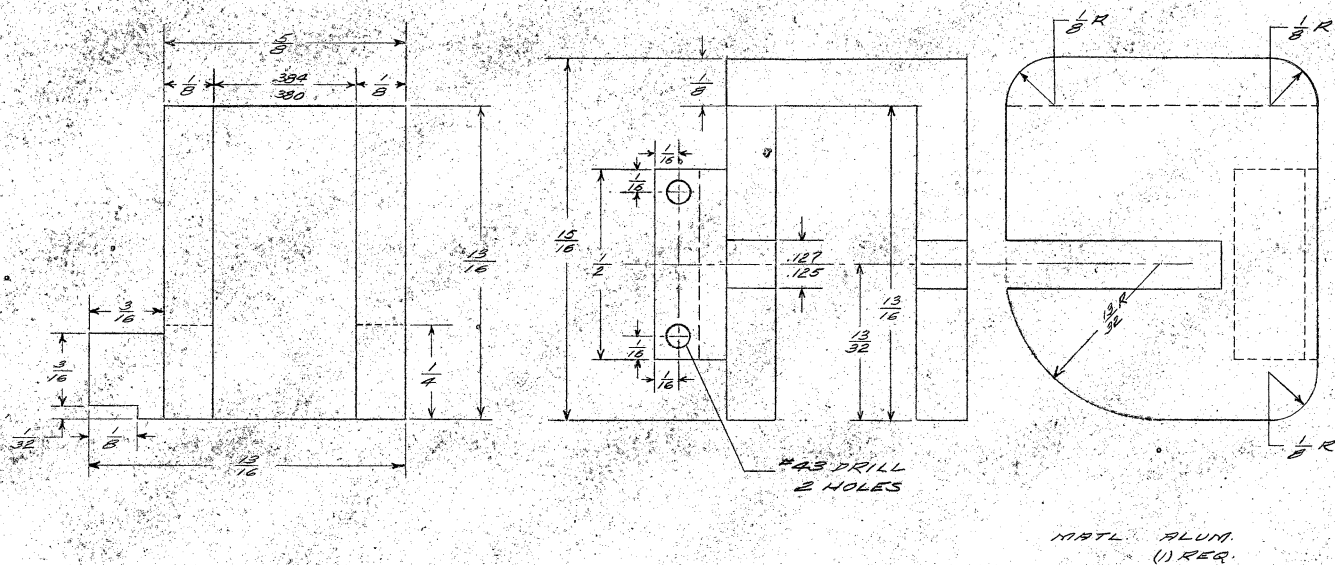
TOLERANCE - FRACTIONAL $\pm 1/64$
DECIMAL $\pm .005$
ANGULAR $\pm 1/2^\circ$
MAT. HALF HARD ALUM.

MAT. HALF HARD ALUM. (1) REQ.

NO	MODIFICATIONS	DR. BY ^{DLC} 4-8-53	SCALE 1"=1"
		CH. BY ² 5-17-53	CHASSIS, AT-1
			DWG. NO. 2045-110



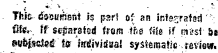
NO. MODIFICATIONS:	DR. BY: RLB-6-53	SCALE: ✓
	ENCL: EJE. 6-10-53	SCHEMATIC AT R 1
		DWG. NO. 2045-22



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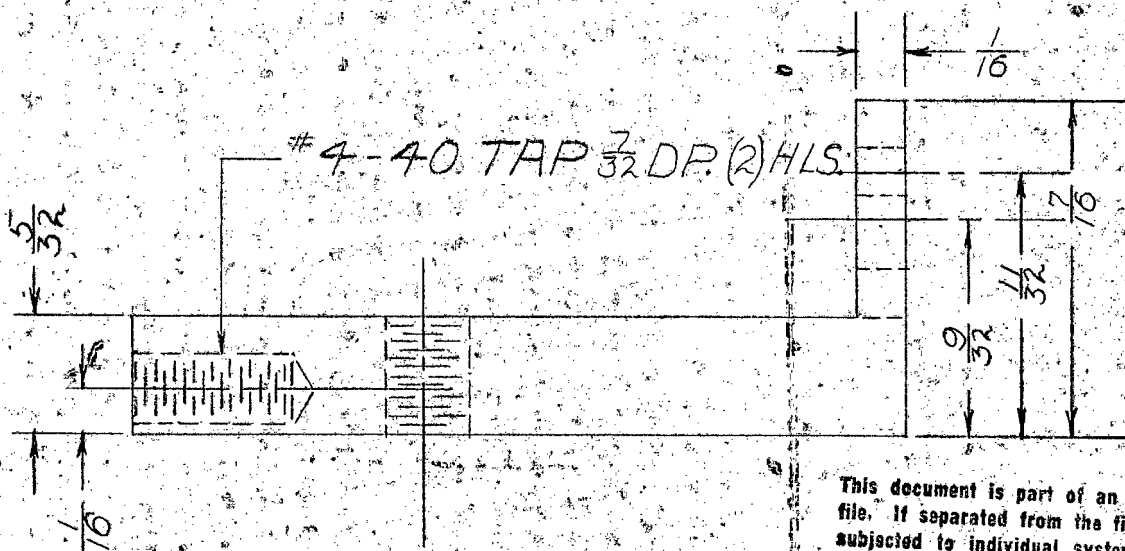
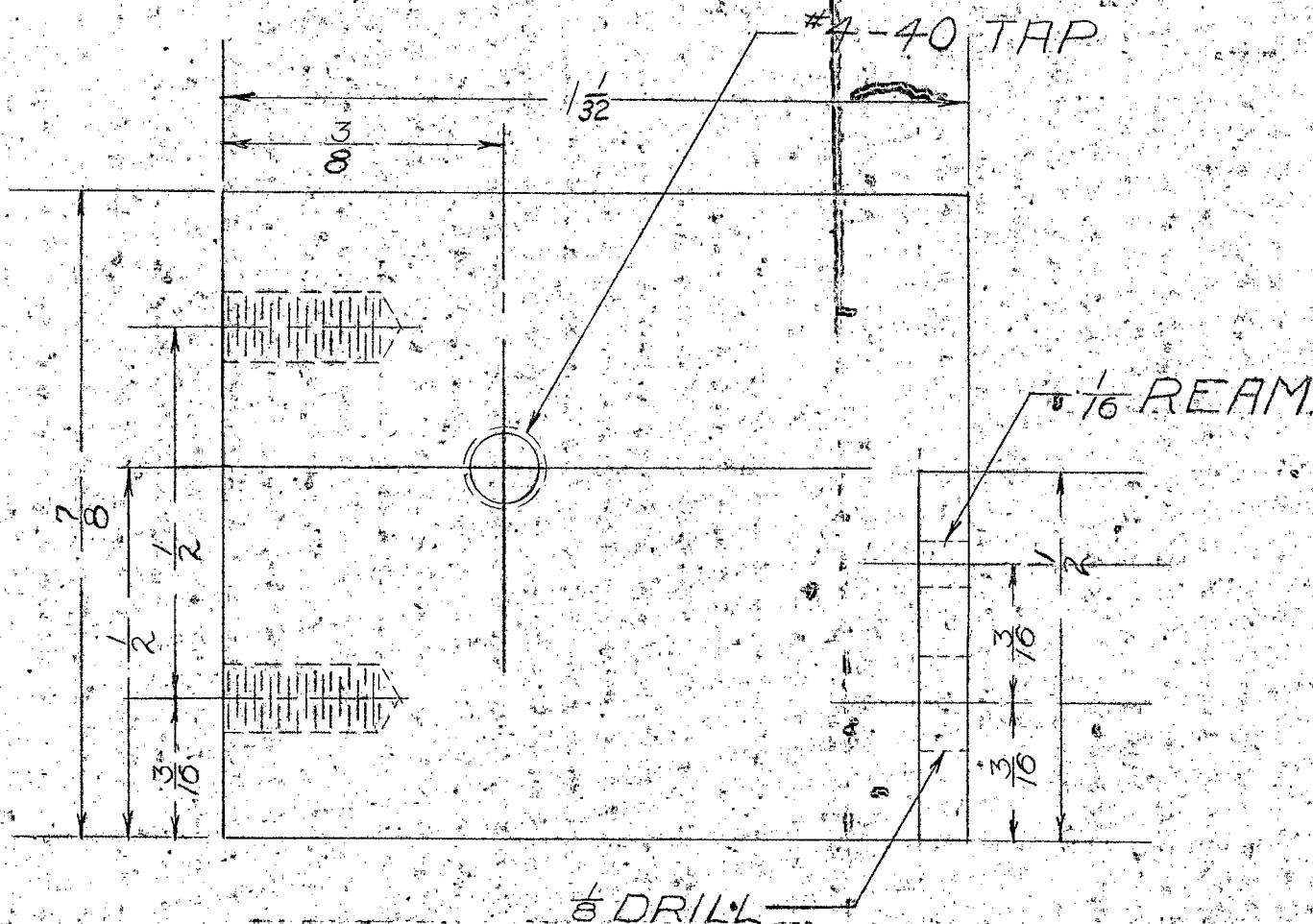
NO.	MODIFICATIONS	DR. BY	DATE	SCALE: 1" = $\frac{1}{4}$ "
		EN. BY		INKER
				FRAME
				PW. NO.
				2045-133

NO.	MODIFICATIONS	OR BN. A.L.B. 6-1-53	SCALE, NAME
		CH. 87.	CHASSIS AP-1
			DWG. NO. 2045-126



MAT. ALUM.

NO.	MODIFICATIONS.	Dr. by: D.L.C. 2-20-53	SCALE 1" = 1/4"
		CH. BY D.L.C.	PLATE, FRAME
			B-2045-13

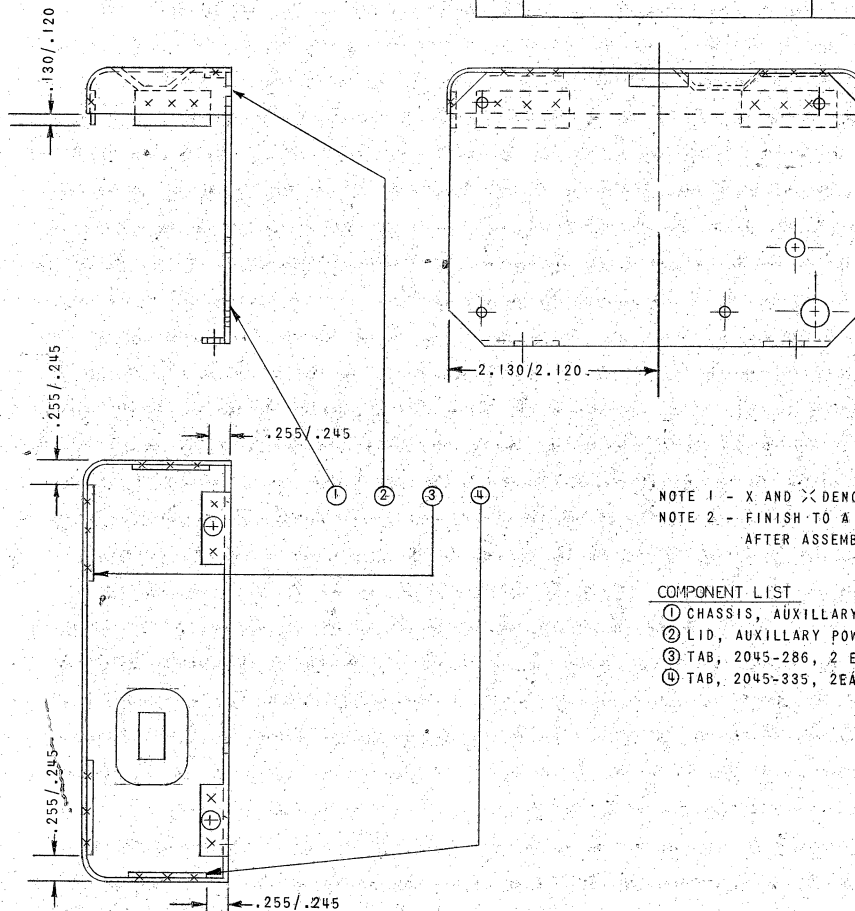


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(1) REQ. L. MAT. ALUM.

NO	MODIFICATIONS	Dr. by D.L.C. 2-18-53	SCALE 1" = 1/4"
		CH. BY D.L.C.	SUPPORT
			H-2045-14

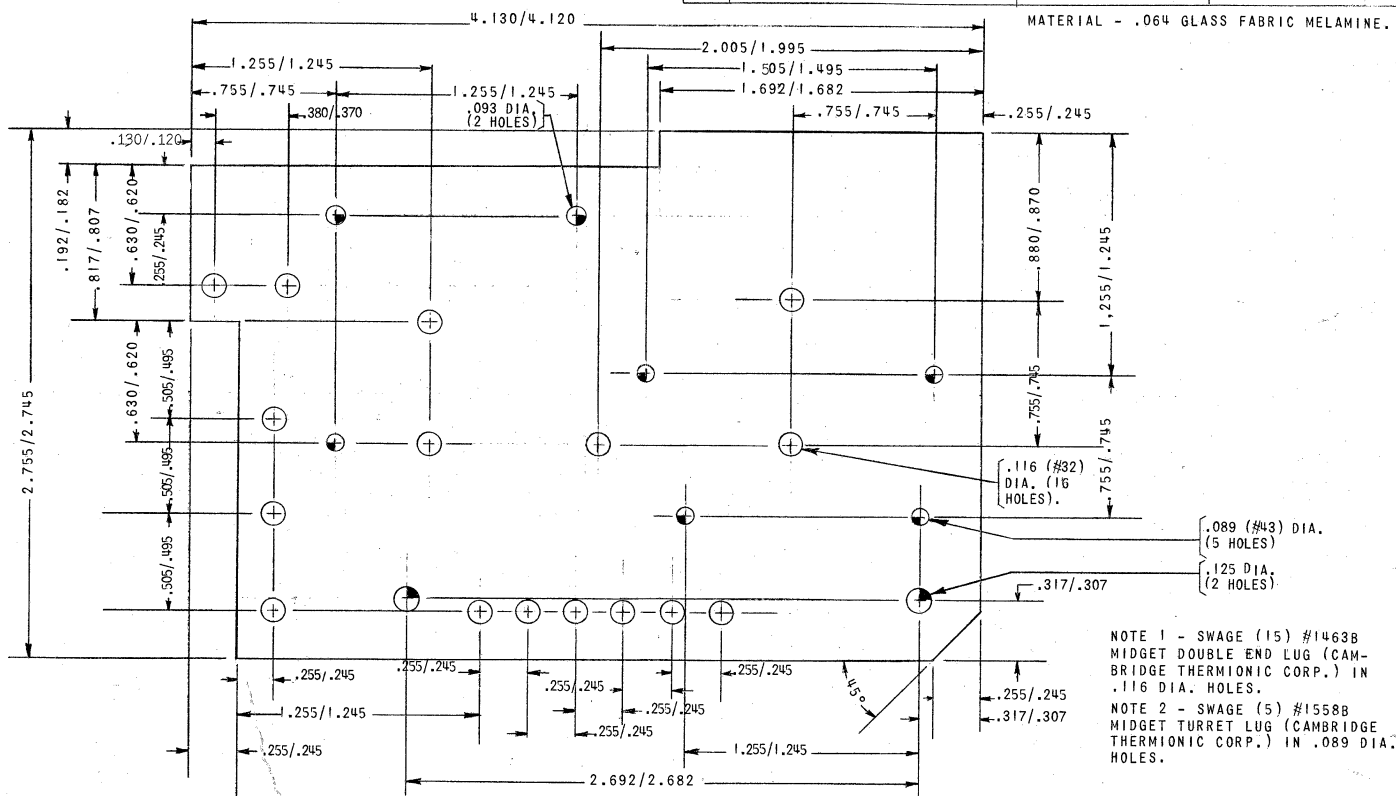
NO.	MODIFICATIONS	DR. BY <i>amb</i>	11-22-55	SCALE 1"=1"
		CH. BY		ASSEMBLY, LID, CHASSIS
		QUANTITY-1		AUX. POWER SUPPLY
				2045-503



NOTE 1 - X AND X DENOTE SPOT WELD.
 NOTE 2 - FINISH TO A NON-REFLECTING BLACK COLOR
 AFTER ASSEMBLY.

COMPONENT LIST

- ① CHASSIS, AUXILLARY POWER SUPPLY, 2045-506; 1 EA.
- ② LID, AUXILLARY POWER SUPPLY, 2045-507, 1 EA.
- ③ TAB, 2045-286, 2 EA.
- ④ TAB, 2045-335, 2EA.



NO.	MODIFICATIONS	DR. BY	SCALE 1"=1/4"
		CH. BY	SHAFT, HELIX WORM
		QUANTITY-1	2045-203

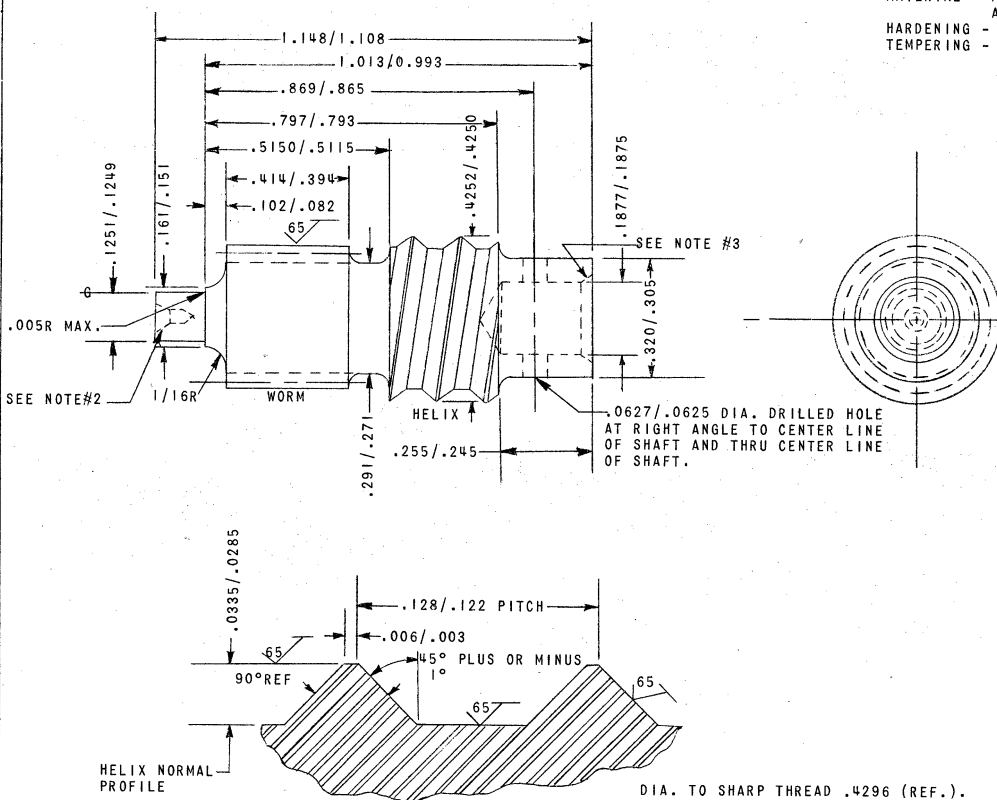
MATERIAL - MAX-EL 3-1/2 ALLOY MACHINE STEEL, CRUCIBLE STEEL CO. OF AMERICA.

HARDENING - HEAT TO 1525°-1575° F. AND QUENCH IN OIL.

TEMPERING - TEMPER IMMEDIATELY TO 42-45 ROCKWELL "C" BY HEATING TO 900°F FOR 45 MINUTES AND AIR COOL.

-WORM DATA-

PRESSURE ANGLE	20°
RIGHT HAND 48 PITCH	2 THREADS
LEAD	.1309
PITCH	.0654
PITCH DIAMETER	.3333
LEAD ANGLE	7°7'
OUTSIDE DIAMETER	.3749
BOTTOM DIAMETER	.2851



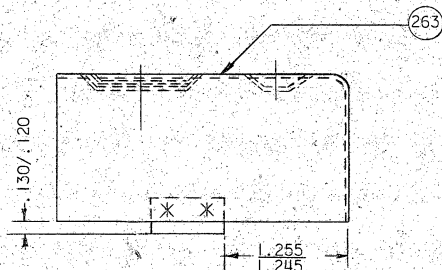
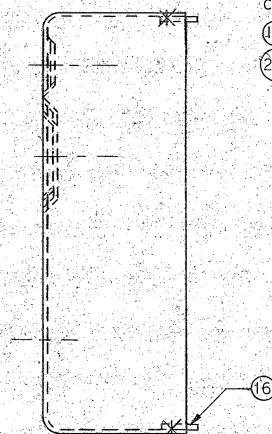
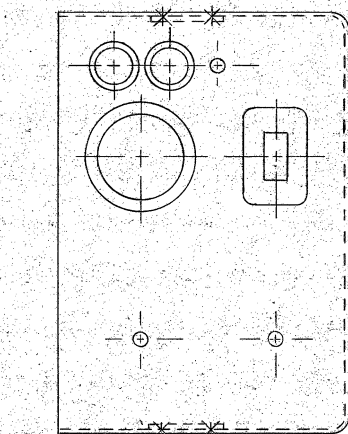
- NOTE #1 - ALL FILLET RADII TO BE 1/32 UNLESS OTHERWISE DESIGNATED.
- NOTE #2 - .080 MAX. DIA. OF C'SINK FOR CENTER ON WORM END. LAP OUT AFTER H. AND T.
- NOTE #3 - .250 MAX. DIA. OF C'SINK FOR CENTER ON HELIX END. LAP AFTER H. AND T.
- NOTE #4 - P.D. OF WORM AND O.D. OF HELIX TO BE CONCENTRIC WITH .1250 BEARING JOURNAL WITHIN .0004 TOTAL INCLUDED RUNOUT.
- NOTE #5 - .1877/.1875 DIA. HOLE TO BE CONCENTRIC WITH .1250 BEARING JOURNAL WITHIN .0004 TOTAL INCLUDED RUNOUT.
- NOTE #6 - CHROME PLATE HELIX ONLY. .0001 TO .00015 THICK. POLISH TO ROUGHNESS AS INDICATED (A.A. VALUE) BEFORE PLATING.
- NOTE #7 - GRIND ONLY .1251/.1249 BEARING JOURNAL.
- NOTE #8 - O.D. OF TRUNCATED HELIX TO INCLUDE PLATING.
- NOTE #9 - WORM AND TOOTH TO TOOTH COMPOSITE ERROR LIMITS TO BE OF A COMMERCIAL 3/AGMA 236.03 CLASS.
- NOTE #10 - WORM TEETH TO BE POLISHED AFTER H. AND T. TO ROUGHNESS AS INDICATED (A.A. VALUE).
- NOTE #11 - HELIX TO BE LEFT HAND.

DR. BY	COM	SCALE	1" = 1"
CH. BY		LID, RECEIVER	
QUANTITY-1		2045-338	

NOTE 1 - * DENOTE SPOT WELD.
 NOTE 2 - FINISH TO A NON-REFLECTING
 BLACK COLOR AFTER ASSEMBLY.

COMPONENT LIST

(16) TAB 2045-335 2EA
 (263) LID, RECEIVER 2045-263. 1EA



WORM DATA

WORM WHEEL DATA

PRESSURE ANGLE	25°	PRESSURE ANGLE	20°
RIGHT HAND 48 PITCH	4 THREADS	RIGHT HAND 48 PITCH	DOUBLE
LEAD	.2619	TEETH	20
PITCH	.0654	PITCH DIA.	.4167
PITCH DIA.	.3333	THROAT DIA.	.4583
LEAD ANGLE	14°2'	RAD. OF WORM WHEEL THROAT	.1459
OUTSIDE DIA.	.3749	OUTSIDE DIA. (TO SHARP COR.)	.4895
BOTTOM DIA.	.2851	CORNER RADIUS MAX.	.0156

NOTE#1. ALL FILLET RADII TO BE 1/32" UNLESS OTHERWISE DESIGNATED.

NOTE#2. .080 MAX. DIA. OF C'SINK FOR CENTER ON BOTH ENDS. LAP OUT AFTER H. AND T.

NOTE#3. P.D. OF BOTH WORM AND WORM-WHEEL TO BE CONCENTRIC WITH .1250 BEARING JOURNALS WITHIN .0004 TOTAL INCLUDED RUNOUT.

NOTE#4. GRIND ONLY .1251/.1249 BEARING JOURNALS.

NOTE#5. WORM AND TOOTH TO TOOTH COMPOSITE ERROR LIMITS TO BE OF A COMMERCIAL 3/AGMA 236.03 CLASS.

NOTE#6. WORM-WHEEL AND TOOTH TO TOOTH COMPOSITE ERROR LIMITS TO BE OF A COMMERCIAL 3/AGMA 236.03 CLASS.

NOTE#7. WORM-TEETH TO BE POLISHED AFTER H. AND T. TO ROUGHNESS AS INDICATED (A.A. VALUE).

NOTE#8. WORM-WHEEL TEETH TO BE MACHINED TO ROUGHNESS AS INDICATED (A.A. VALUE).

NOTE#9. STRAIGHT KNURL WITH A 32 TEETH/IN. AND 60° INCLUDED ANGLE KNURL. BREAK CORNER 1/32x15° MAX. AFTER KNURLING.

NOTE#10. AFTER H. AND T. PRESS THE COUNTERSHAFT (PT.A) KNURLED SECTION INTO THE WORM-WHEEL BLANK (PT.B) AND MACHINE WORM-WHEEL TO COMPLETION AS SHOWN.

MODIFICATIONS

1 3 HOLES ADDED 2/14/56

DR. BY *RM* 10-27-55

CH. BY

QUANTITY-1

SCALE 1"=1/2"

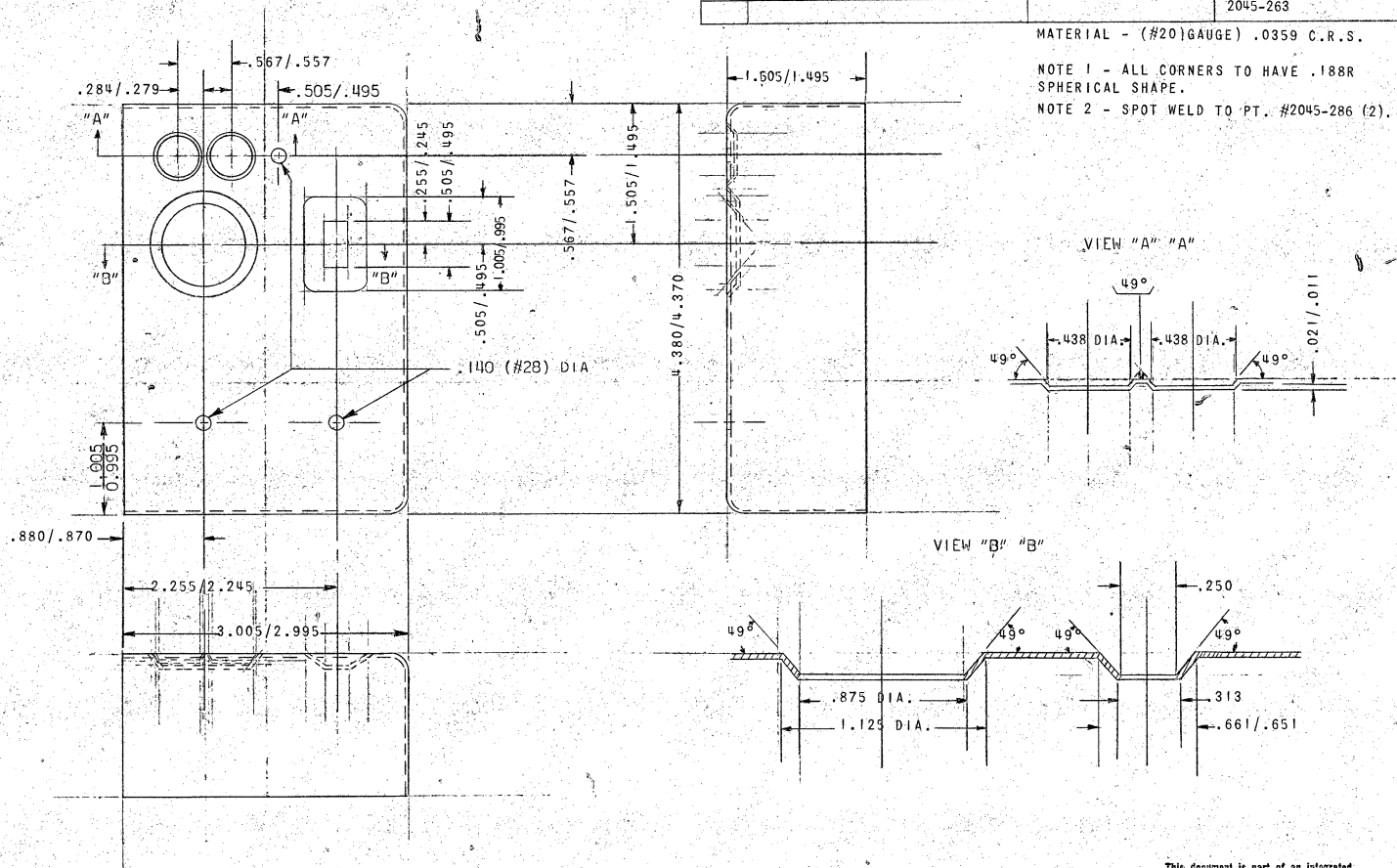
LID, RECEIVER

2045-263

MATERIAL - (#20) GAUGE .0359 C.R.S.

NOTE 1 - ALL CORNERS TO HAVE .188R
SPHERICAL SHAPE.

NOTE 2 - SPOT WELD TO PT. #2045-286 (2).



Technical drawing of a mechanical part, showing side and end views with dimensions.

Side View Dimensions:

- Overall length: 1.255 / 1.245
- Top edge thickness: .065 / .060
- Top edge width: .025 / .023
- Top edge width: .062 / .052
- Top edge width: .193 / .183
- Top edge width: .3127 / .3125
- Top edge width: .380 / .375
- Top edge width: .10332 / 1.0330
- Top edge width: .1515 / 1.1505

End View Dimensions:

- Overall diameter: .381 / .376
- Top edge width: .154 (#23) DIA. THRD. (2 HOLES)
- Top edge width: .193 / .183
- Top edge width: .130 / .120
- Top edge width: .375 R - REF.
- Top edge width: .327 / .322
- Top edge width: .380 / .370
- Top edge width: .096 (#41) DIA. THRU 3 HOLES.
- Top edge width: .4375 R - REF.
- Top edge width: .221 / .216
- Top edge width: .440 / .435
- Top edge width: .120° REF.
- Top edge width: .30° REF.
- Top edge width: .120° REF.

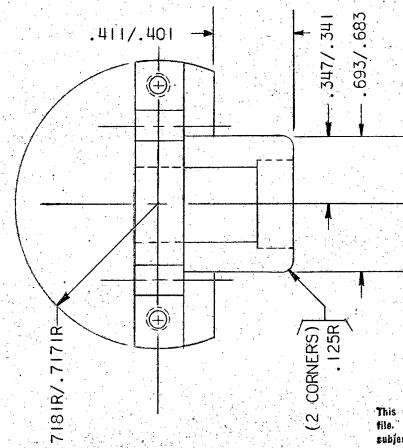
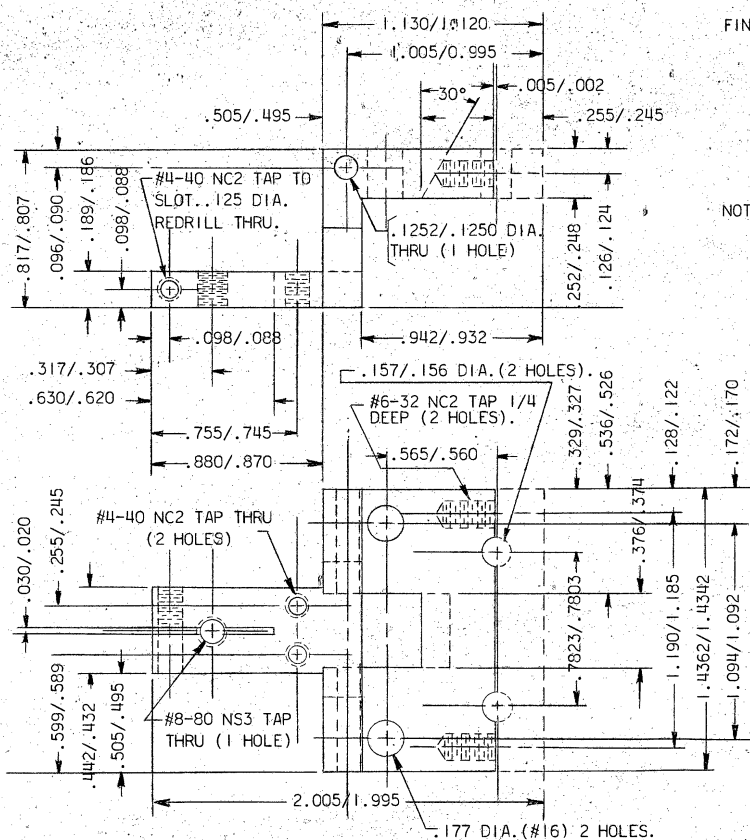
Other Features:

- .016 MAX. x 45° CHAMFER.

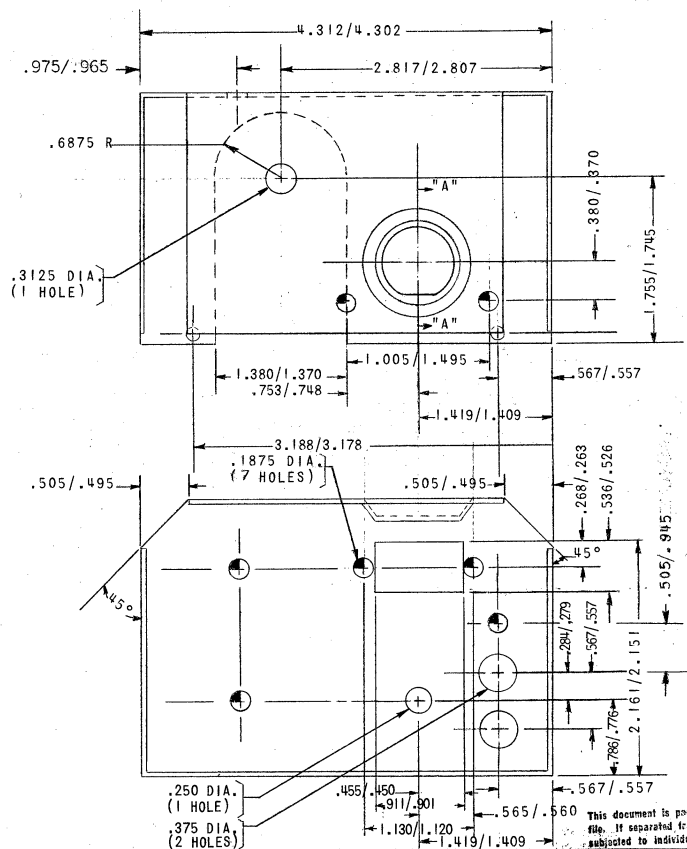
NO. MODIFICATIONS	DR. BY <i>R.M.E.</i>	SCALE 1"=1/2"
	CH. BY	FRAME, ELECTROMAGNETIC MOUNTING
	QUANTITY-1	2045-236

MATERIAL 2924 ALUMINIUM MINIMUM HARDNESS TO BE EQUIV. TO T4 (2024-T4).
OLD DESIG. (24S-T4).
FINISH CLEAR ANODIZE.

NOTE#1. MACHINE AWAY DOTTED SECTION AFTER THE .157/.156 DIA. HOLES ARE MACHINED IN.



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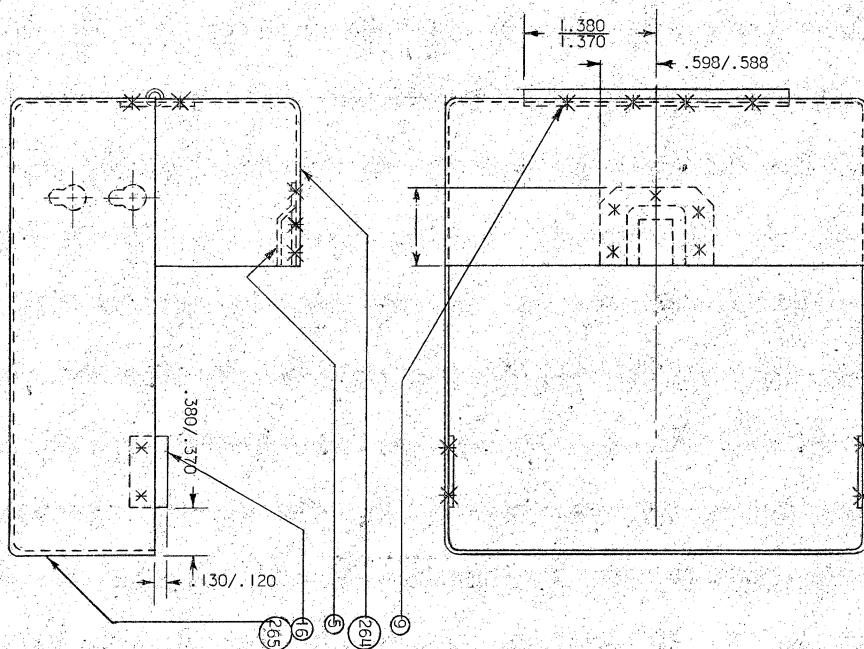
NO.	MODIFICATIONS	DR. BY	SCALE 1" = 1"
		CH BY	ASSEMBLY, CASE &
		QUANTITY - 1	LID RECEIVER
			2045-266

NOTE: ① * & * DENOTE SPOT WELD.

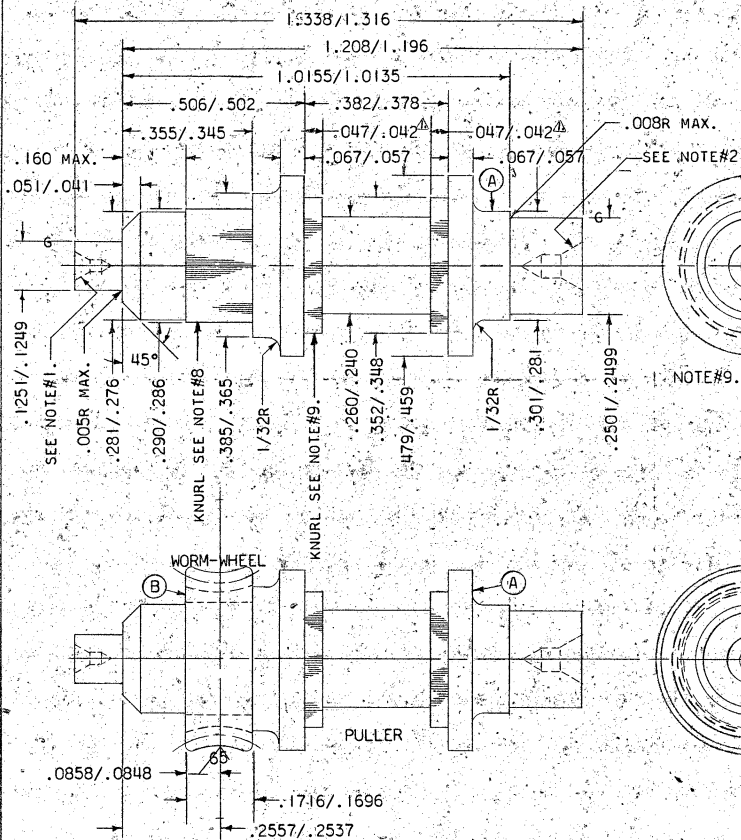
NOTE: ② FINISH TO A NON-REFLECTING BLACK COLOR AFTER ASSEMBLY

COMPONENT LIST

- ⑤ HOUSING LATCH 2045-287. 1EA
- ③ HINGE 2045-291. 1EA
- ①⑥ TAB 2045-335. 2EA
- ②⑥④ LID, RECEIVER 2045-264. 1EA
- ②⑥⑤ CASE, RECEIVER 2045-265 1EA



NO.	MODIFICATIONS	DR. BY	SCALE 1"=1/4"
1	ADDED .047/.042 DIM. FEB-16-55	CH. BY <i>RM.B.</i>	SHAFT, PULLER,
		QUANTITY-1	WORM-WHEEL
			2045-205



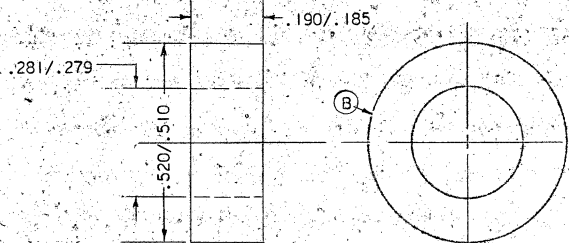
MATERIAL - PT. A - MAX-EL. 3-1/2 ALLOY MACHINE STEEL, CRUCIBLE STEEL CO. OF AMERICA.
HARDENING - HEAT TO 1525°-1575° F. AND QUENCH IN OIL.
TEMPERING - TEMPER IMMEDIATELY TO 42-45 ROCKWELL "C" BY HEATING TO 900° F FOR 45 MINUTES AND AIR COOL.

PT. B - PHOSPHOR GEAR BRONZE (CAST) SAE#65

NOTE#	WORM-WHEEL DATA
NOTE#7. AFTER H. AND T. PRESS THE PULLERSHAFT (PT. A) KNURLED SECTION INTO THE WORM-WHEEL BLANK (PT. B) AND MACHINE WORM-WHEEL TO COMPLETION AS SHOWN.	PRESSURE ANGLE 26° RIGHT HAND 48 PITCH FOUR THREADS TEETH 20 PITCH DIA. .4167 THROAT DIA. .4583 RAD. OF WORM-WHEEL THROAT .1459 OUTSIDE DIA. (TO SHARP COR.) .4789 CORNER RADIUS MAX. .0156
NOTE#8. STRAIGHT KNURL WITH A 32 TEETH/IN. AND 60° INCLUDED ANGLE KNURL.	

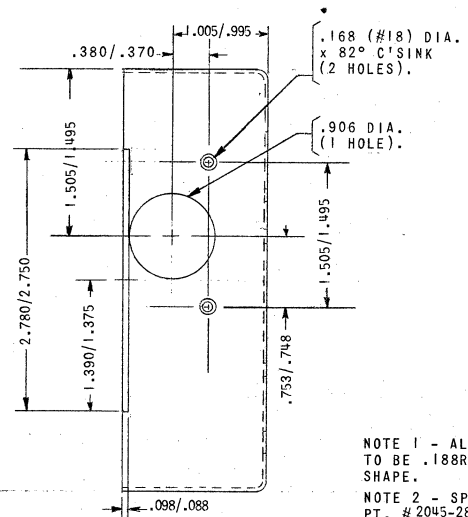
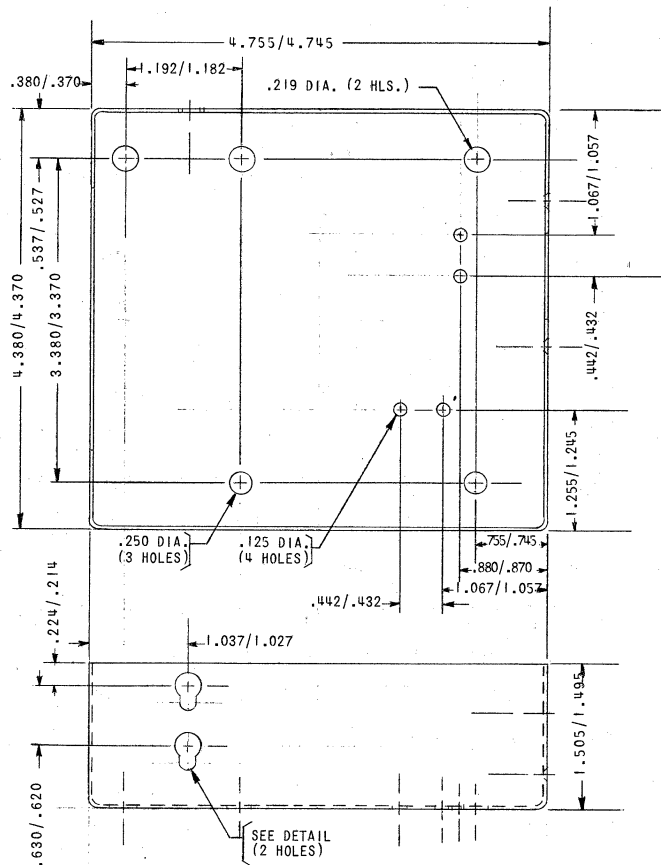
NOTE#9. STRAIGHT KNURL WITH A 32 TEETH/IN. AND 60° INCLUDED ANGLE KNURL. .352/.348 DIA. TO BE TO A FULL SHARP KNURL. KNURL ENTIRE SURFACE INTO CORNERS. KNURL ON BOTH SIDES TO BE SAME DIA. WITHIN .001

NOTE#1. .080 MAX. DIA. OF C'SINK FOR CENTER ON WORM-WHEEL END. LAP OUT AFTER H. AND T.
NOTE#2. .188 MAX. DIA. OF C'SINK FOR CENTER ON PULLER END. LAP OUT AFTER H. AND T.
NOTE#3. P.D. OF WORM-WHEEL AND KNURLED DIA. OF PULLER TO BE CONCENTRIC WITH BEARING JOURNALS WITHIN .0004 TOTAL INCLUDED RUNOUT.
NOTE#4. GRIND ONLY .1251/.1249 AND .2501/.2499 BEARING JOURNALS.
NOTE#5. WORM-WHEEL AND TOOTH TO TOOTH COMPOSITE ERROR LIMITS TO BE OF A COMMERCIAL 3/AGMA 236.03 CLASS.
NOTE#6. WORM-WHEEL TEETH TO BE MACHINED TO ROUGHNESS AS INDICATED. (A.A. VALUE).



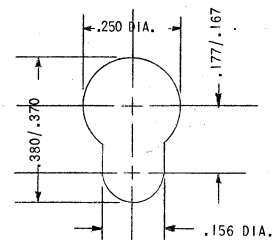
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NO.	MODIFICATIONS	DR. BY <i>P.M.L.</i> 10-21-85	SCALE 1"=1"
		CH. BY	CASE, RECEIVER
		QUANTITY-1	2045-265
MATERIAL - (#20 GAUGE) .0359 C.R.S.			



NOTE 1 - ALL CORNERS TO BE .188R SPHERICAL SHAPE.

NOTE 2 - SPOT WELD TO PT. # 2045-286 (2) and 2045-291 (1)



DETAIL of HOLE FOR PAPER REEL HOLDER CLIP-ON.

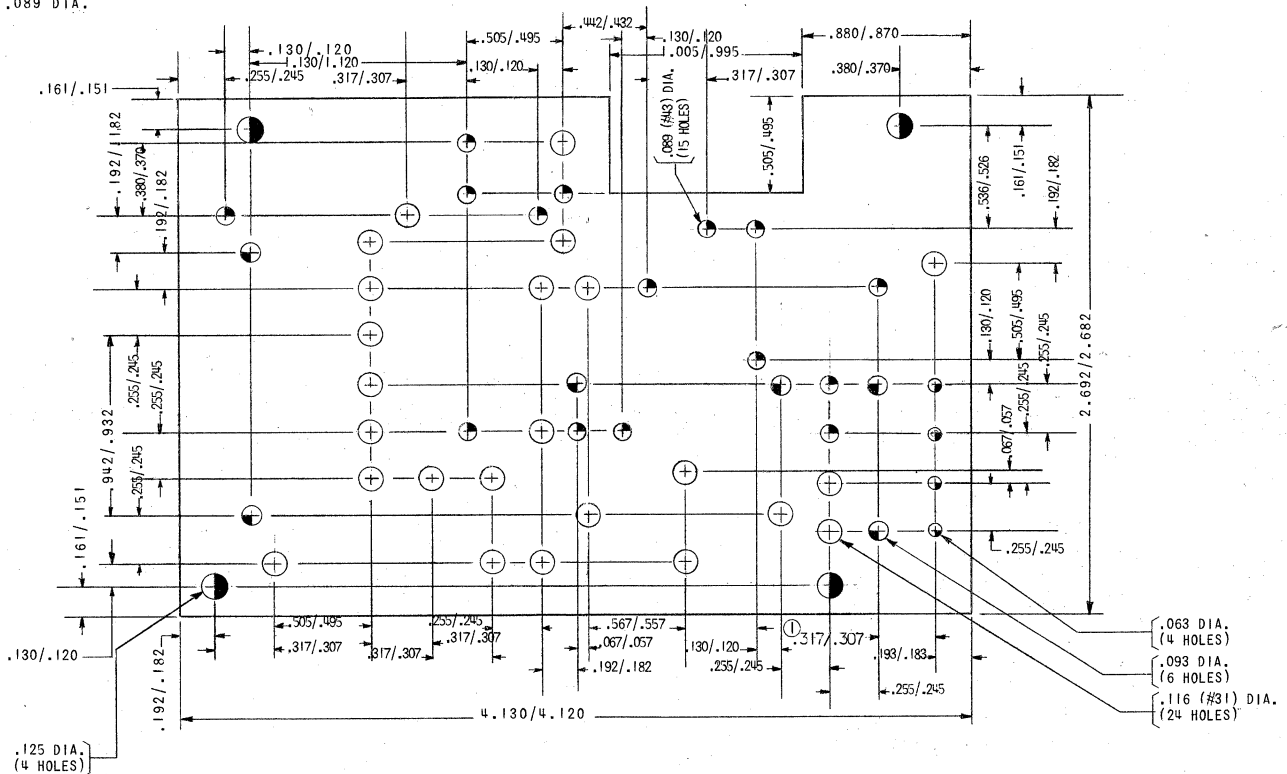
This document is part of an integrated file. If separated from the file it must be subjected to individual systematic review.

NOTE 1 - SWAGE (24) #14638
MIDGET DOUBLE END LUGS (CAM-
BRIDGE THERMIONIC CORP.) IN
.116 DIA. HOLES.

NOTE 2 - SWAGE (12) #15588
MIDGET TURRET LUGS (CAMBRIDGE
THERMIONIC CORP.) IN .089 DIA.
HOLES.

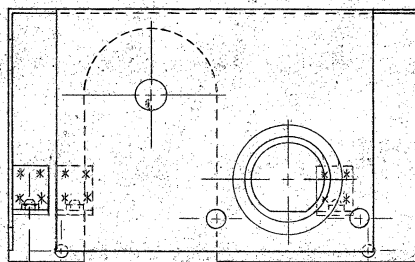
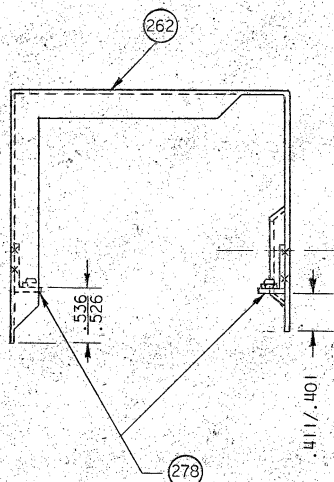
NO.	MODIFICATIONS	DR. BY	SCALE
①	WAS .192/.182 2-15-56	CH. BY	11-1-55
		QUANTITY - 1	BOARD, MOUNTING
			2045-292

MATERIAL - .064 GLASS FABRIC MELAMINE.



This document is not to be interpreted
as a specification. It is to be used as a
reference to individual systems or items.

NO.	MODIFICATIONS	DR. BY. <i>ECM</i>	SCALE 1" = 1"
		CH. BY.	ASSEMBLY, CHASSIS
		QUANTITY-1	2045-337



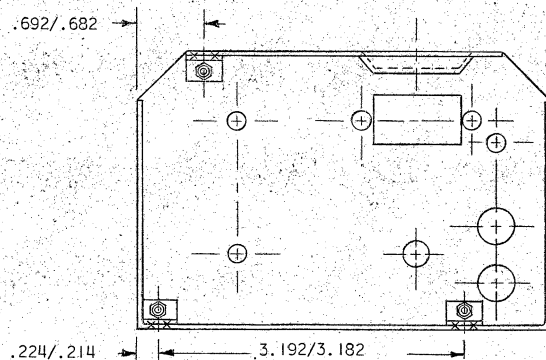
NOTE: 1. * DENOTES SPOT WELD.

NOTE: 2D FINISH TO A NON-REFLECTING BLACK.

NOTE: 3. #4-40 ELASTIC STOP NUTS TO BE INSERTED IN PT# 2045-278 BEFORE SPOT WELDING PT# 2045-278 TO PT# 2045-262

COMPONENT LIST

262	CHASSIS, RECEIVER #2045-262	1EA.
278	BRACKET, MOUNTING #2045-278	3EA.



NO. MODIFICATIONS	DR. BY <i>OML</i> , 11-21-55	SCALE 1"=1"
	CH. BY	ASSEMBLY, CASE
	QUANTITY-1	POWER SUPPLY
		2045-402

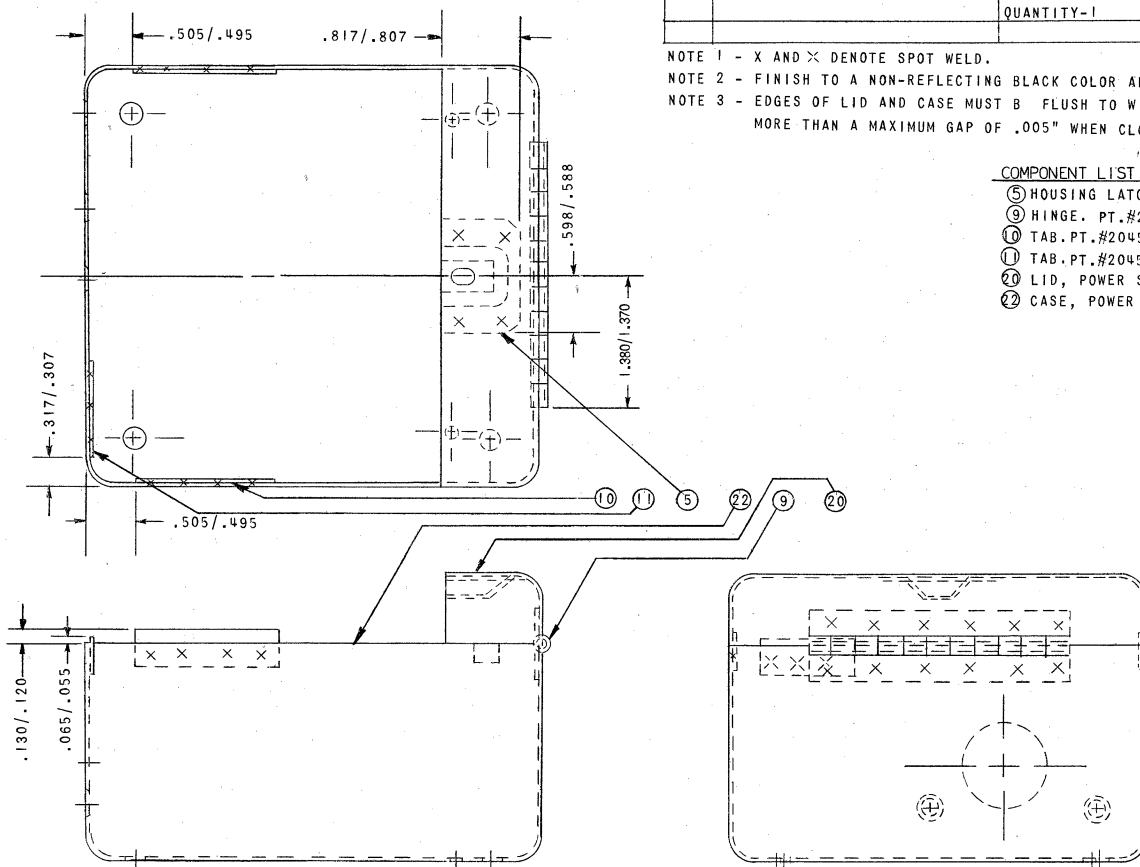
NOTE 1 - X AND X DENOTE SPOT WELD.

NOTE 2 - FINISH TO A NON-REFLECTING BLACK COLOR AFTER ASSEMBLY.

NOTE 3 - EDGES OF LID AND CASE MUST BE FLUSH TO WITHIN .005", AND NOT HAVE MORE THAN A MAXIMUM GAP OF .005" WHEN CLOSED.

COMPONENT LIST

- ⑤ HOUSING LATCH. PT. #2045-287 1ea.
- ⑨ HINGE. PT. #2045-291 1ea.
- ⑩ TAB. PT. #2045-409 2ea.
- ⑪ TAB. PT. #2045-286 1ea.
- ⑫ LID, POWER SUPPLY. PT. #2045-408 2ea.
- ⑬ CASE, POWER SUPPLY. PT. #2045-404 1ea.



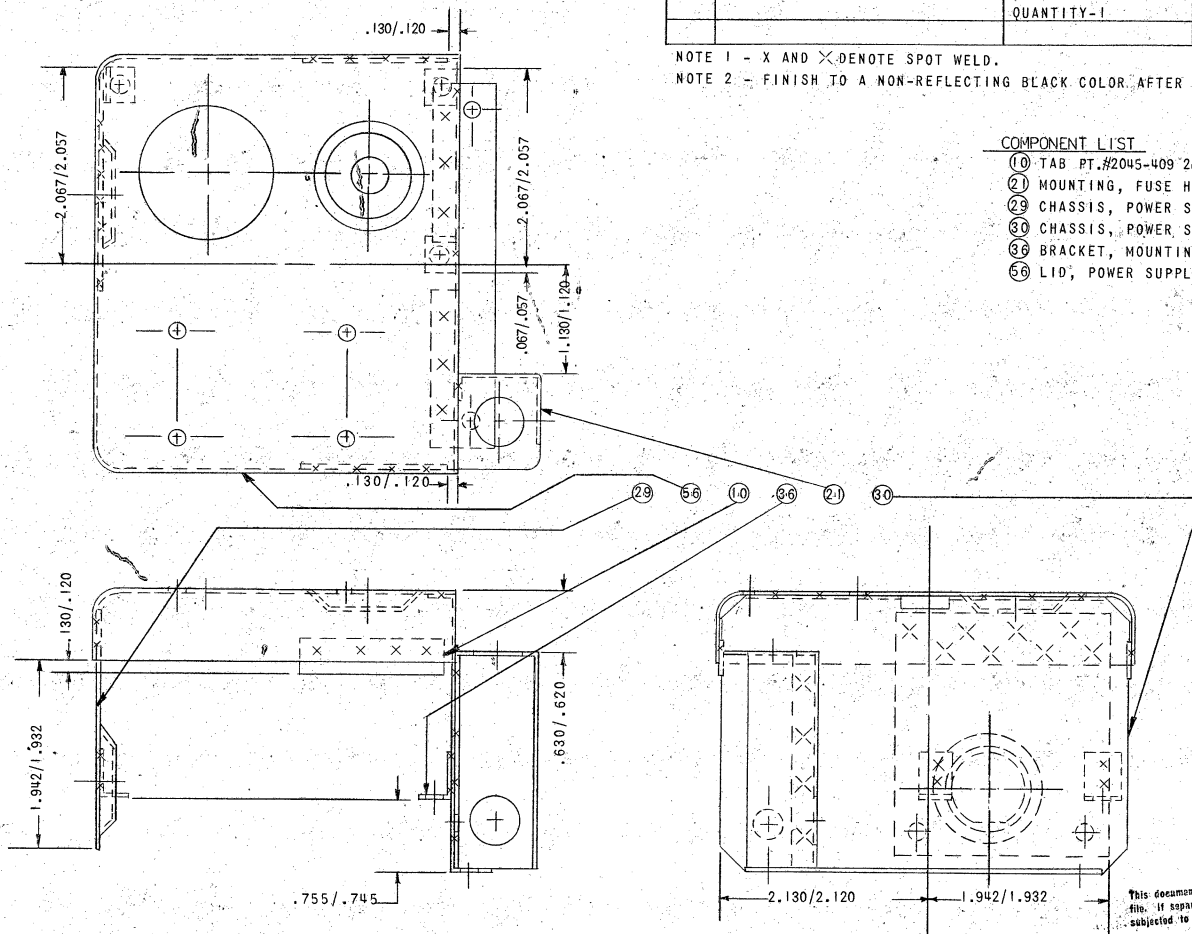
NO.	MODIFICATIONS	DR. BY	SCALE
1	13 HOLES REMOVED. SEE MOD. 1 ON 2045-407. 2-6-58.	CH. BY	ASSEMBLY, LID, CHASSIS POWER SUPPLY.
		QUANTITY-1	2045-403

NOTE 1 - X AND X DENOTE SPOT WELD.

NOTE 2 - FINISH TO A NON-REFLECTING BLACK COLOR AFTER ASSEMBLY.

COMPONENT LIST

- (10) TAB PT.#2045-409 2ea.
- (21) MOUNTING, FUSE HOLDER PT.#2045-410 1ea.
- (29) CHASSIS, POWER SUPPLY PT.#2045-406 1ea.
- (30) CHASSIS, POWER SUPPLY PT.#2045-405 1ea.
- (36) BRACKET, MOUNTING PT.#2045-278 3ea.
- (56) LID, POWER SUPPLY PT.#2045-407 1ea.



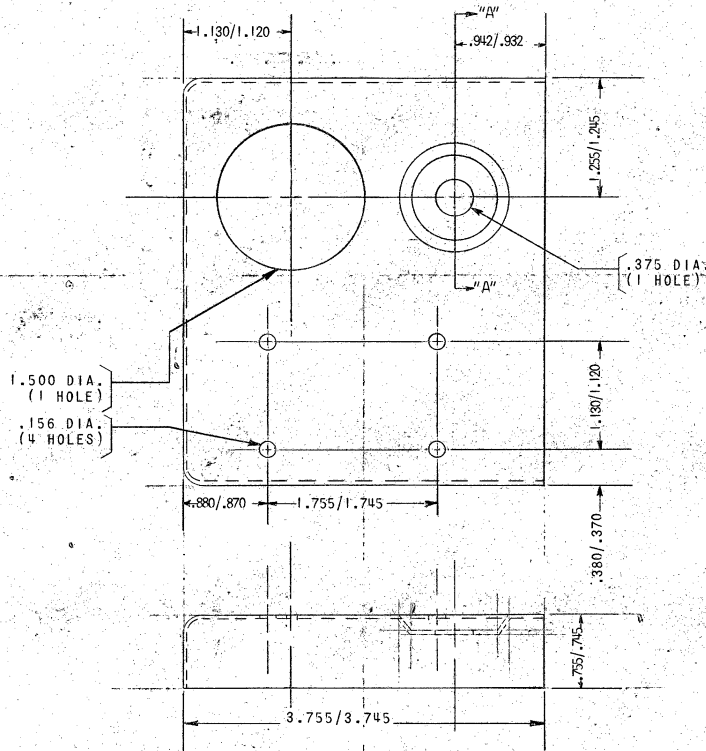
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NO.	MODIFICATIONS	DR. BY	SCALE
1	(3) .093 DIA. HCS. REMOVED ON PERIMETER OF 1.500 DIA. HL. 2-6-56	10-27-55	1"=1"
		CH. BY	LID, POWER SUPPLY
		QUANTITY-1	2045-407

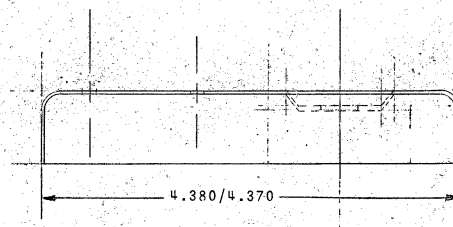
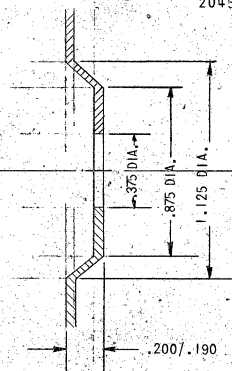
MATERIAL - (#20 GAUGE) .0359 C.R.S.

NOTE 1 - ALL CORNERS TO HAVE .188R SPHERICAL SHAPE AND .188R ON ALL CORNERS.

NOTE 2 - SPOT WELD TO PT. #2045-278, 2045-406, 2045-405 and 2045-409.



VIEW "A" "A"



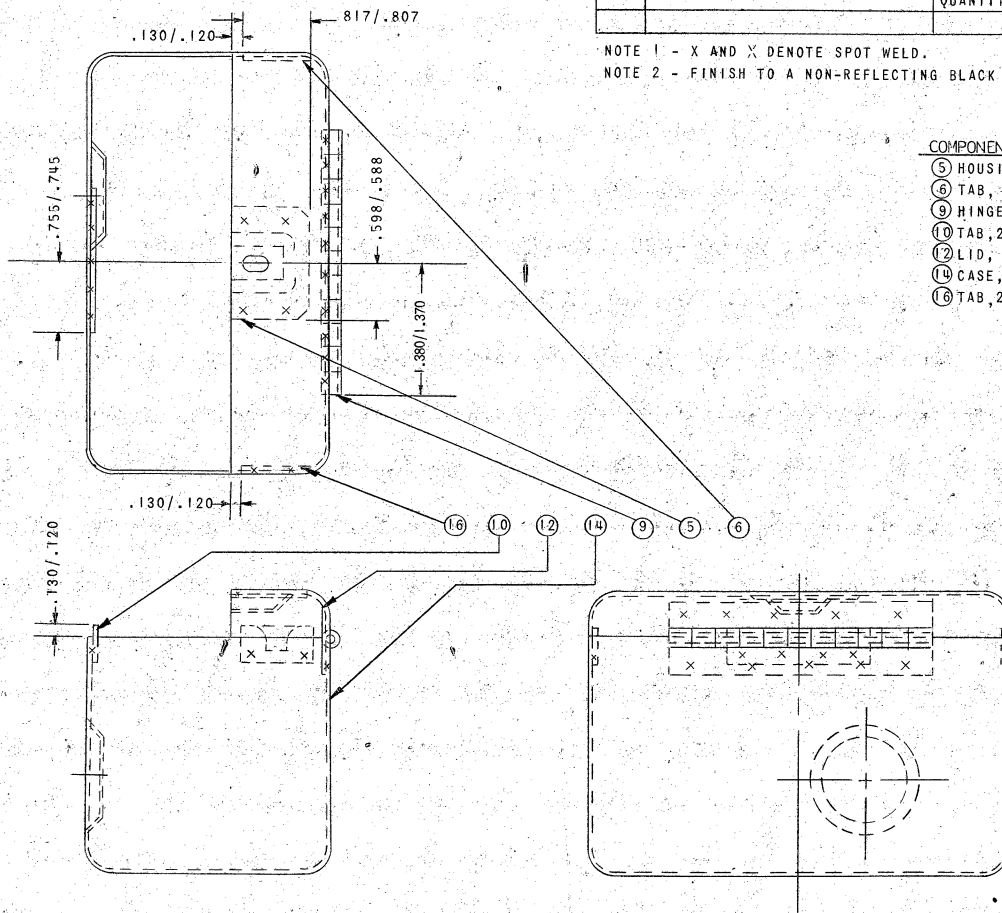
NO.	MODIFICATIONS	DR. BY	DATE	SCALE
		mm	11-18-55	1"=1"
		CH. BY		ASSEMBLY, CASE AND LID,
		QUANTITY-1		AUX. POWER SUPPLY.
				2045-502

NOTE 1 - X AND X DENOTE SPOT WELD.

NOTE 2 - FINISH TO A NON-REFLECTING BLACK COLOR AFTER ASSEMBLY.

COMPONENT LIST

- ⑤ HOUSING LATCH, 2045-287, 1 EA.
- ⑥ TAB, 2045-508, 1 EA.
- ⑨ HINGE, 2045-291, 1 EA.
- ⑩ TAB, 2045-409, 1 EA.
- ⑫ LID, AUXILLARY POWER SUPPLY, 2045-505, 1 EA.
- ⑬ CASE, AUXILLARY POWER SUPPLY, 2045-504, 1 EA.
- ⑭ TAB, 2045-335, 1 EA.



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